

Work Order ID 80175

\*80175\*

Page 1

February-13-12 10:40:18 AM

Item ID: D350-591-311

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step, Long LH

Start Date: 13/02/2012 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 2/02/13 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3272	Rev B
-------	-------

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

0.00

110

\*110\*

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod 119785

3-Grind End Plate flush 120169

12.03.13

80175 5XLH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 80175****\*80175\***

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Item ID: D350-591-311

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli-Access-Step, Long LH

Start Date: 13/02/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

5 0 BE 12/03/14

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

802/03/14

XS

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

5X0 m/l 12/03/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D350-591-311 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli-Access-Step, Long LH  
 Start Date: 13/02/2012 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 05/04/2012 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00				564	4	11/10/15	
Quality Control									

180	Large Fab	0.00							
<b>*180*</b>									
Large Fab	Memo	0.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod <u>119785</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

12.03.17  
 12.03.17  
 Ae  
 12.03.22  
 (X5)  
 12.03.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop

\*NS2\*

Item Name: Heli-Access-Step, Long LH

Start Date: 13/02/2012 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

\*190\*

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

\*200\*

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

\*210\*

HandFinish

Memo

0.00

Hand Finishing

PC 12.03.22

5X  
10X

12.03.22 (5)

5 12.3.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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0.00

5 0 (SP) 12/03/30

~~SxØ m/f 12/03/30~~

54 p. 338.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Heli-Access-Step, Long LH

Start Date: 13/02/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

SP 12-04-03 (5x)

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

Sizelutz

45  
49

270

Packaging

0.00

**\*270\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location:

(5x) 12-04-04 SP

Rev D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step, Long LH

Start Date: 13/02/2012 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
*280*									
QC	Memo	0.00							
Quality Control									

12/4/5

12-04-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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February-13-12 10:40:21 AM

Page 1

Work Order ID: 80175

**\*80175\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

## Comments:

IPP Rev:A04.03.22New issue KJ/RF  
IPP Rev:B 07-06-09 Added D3272-1 JLM  
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified  
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1		Manufactured	No			110	Each	20.0000	1	5			
<b>*D3272-1*</b>									**				
Step													

Location	Loc Qty	Loc Code
ST	-10	
WA <u>B80179</u>	30	
78784	10	
78788	10	

D3067-1		Manufactured	No			110	Each	106.0000	1	5			
<b>*D3067-1*</b>									**				
End Plate													

Location	Loc Qty	Loc Code
WA <u>B78608</u>	28	
78022	28	
WA016	78	
67582	2	
68214	1	
79607	75	

D3219-1		Manufactured	No			110	Each	160.0000	2	10			
<b>*D3219-1*</b>									**				
Plate													

Location	Loc Qty	Loc Code
WA016	160	
73410	12	
77674	6	
78763	142	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 80175

**\*80175\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

D3066-1 Manufactured No

180 Each 146.0000 2 10

**\*D3066-1\***

Spacer

\*\*

*Ac 12.03.15*

Location

Loc Qty

Loc Code

WA

146

78605

106

79729

40

MS20600-AD4W4

Purchased No

180 Each 2,618.000 16 80

**\*MS20600-AD4W4\***

Rivets

\*\*

*B120769 Ac 12.03.15*

Location

Loc Qty

Loc Code

ST321

2613

116188

59

117364

253

117601

200

117885

195

118840

1089

119860

30

119883

155

120308

632

WA018

5

116712

5

D3065-041

Manufactured No

180 Each 14.0000 1 5

**\*D3065-041\***

Step Leg Assembly Hi

\*\*

*B78799 (x5) Ac 12.03.15*

Location

Loc Qty

Loc Code

WA

14

66149

0

78797

13

79336

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 80175

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Parent Item: D350-591-311

\*D350-591-311\*

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

D3067-1 Manufactured No

180 Each

106.0000 1 5

\*D3067-1\*

End Plate

\*\*

12.03.20

## Location

## Loc Qty

## Loc Code

WA	78608	28
	78022	28
WA016		78
	67582	2
	68214	1
	79607	75

5

AN3-35A

Purchased No

250 Each

177.0000

\*AN3-35A\*

Bolt

\*\*

2 10 B121068 SP

## Location

## Loc Qty

## Loc Code

ST353		177
	120187	127
	120644	50

Manufactured No

250 Each

25.0000

D3235-1

\*D3235-1\*

Mounting Lug

\*\*

2 10 B78787 SP 12-04-03

## Location

## Loc Qty

## Loc Code

ST471		20
	77566	20
ST481		5
	75547	5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-591-311

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

D3278-041 Manufactured No 250 Each 41.0000

**\*D3278-041\***

Support Assembly

\*\*

1 5

B78795 SP

Location Loc Qty Loc Code

ST481 41

77057 1

78794 40

AN960JD416 NAS1149D0463J Purchased No 250 Each 8.0000

**\*AN960.ID416\***

Washer

\*\*

16 80

M121011 SP

Location Loc Qty Loc Code

ST351 8

116289 8

AN960JD516 NAS1149D0563J Purchased No 250 Each 0.0000

**\*AN960.ID516\***

Washer

\*\*

4 20

M119717 SP

AN5-36A Purchased No 250 Each 207.0000

**\*AN5-36A\***

Bolt

\*\*

2 10

SP

Location Loc Qty Loc Code

ST340 207

120187 192

120423 15

D2618 Manufactured No 250 Each 206.0000

**\*D2618\***

Bushing

\*\*

2 10

SP 12-04-03

Location Loc Qty Loc Code

ST012 206

76130 2

77563 4

78537 200

10X

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Shop Packet Print

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-591-311

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

D2230-3 Manufactured No

250 Each

16.0000

\*D2230-3\*

Lug

4 20

\*\* SP 380009. SP

## Location

## Loc Qty

## Loc Code

ST480

16

53881

4

70973

1

77561

11

D2856-400 Manufactured No

250 f

241.0073

1.2

6

\*D2856-400\*

Abraison Strip

\*\*

SP

SP

## Location

## Loc Qty

## Loc Code

ST409

241.007258

63735

0.6696

68076

0.3149

71164

21.66

73491

2.362758

79551

216

\*\*\* cut (2) at 7.20" (D2856-400-720) \*\*\*

MS21042L3

Purchased No

250 Each

4,835.000

10

\*MS21042L3\*

Nut

\*\*

SP 12-04-02

SP

## Location

## Loc Qty

## Loc Code

ST300

4835

117441

25

117885

32

118451

5

118927

3

119017

4372

119075

398

10X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

AN4-13A  
**\*AN4-13A\***

Bolt

Purchased No

250 Each

1,357.000

8 40

\*\*

## Location

## Loc Qty

## Loc Code

ST357

1357

119449

59

120187

798

120422

500

Purchased No

250 Each

1,790.000

2 10

\*\*

MS21042L5

**\*MS21042I 5\***

Nut

## Location

## Loc Qty

## Loc Code

ST300

1790

116105

5

116548

43

117611

42

118179

200

119109

1500

Purchased No

250 Each

5,401.000

8 40

\*\*

MS21042L4

**\*MS21042I 4\***

Nut

## Location

## Loc Qty

## Loc Code

ST300

5401

117441

59

117601

157

118451

133

119017

200

119075

4852

Purchased No

250 Each

0.0000

4 20

\*\*

AN960JD10

**\*AN960.ID10\***

Washer

February-13-12 10:40:22 AM

Shop Packet Print

Page 6

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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*80175 Rev 5  
12/02/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

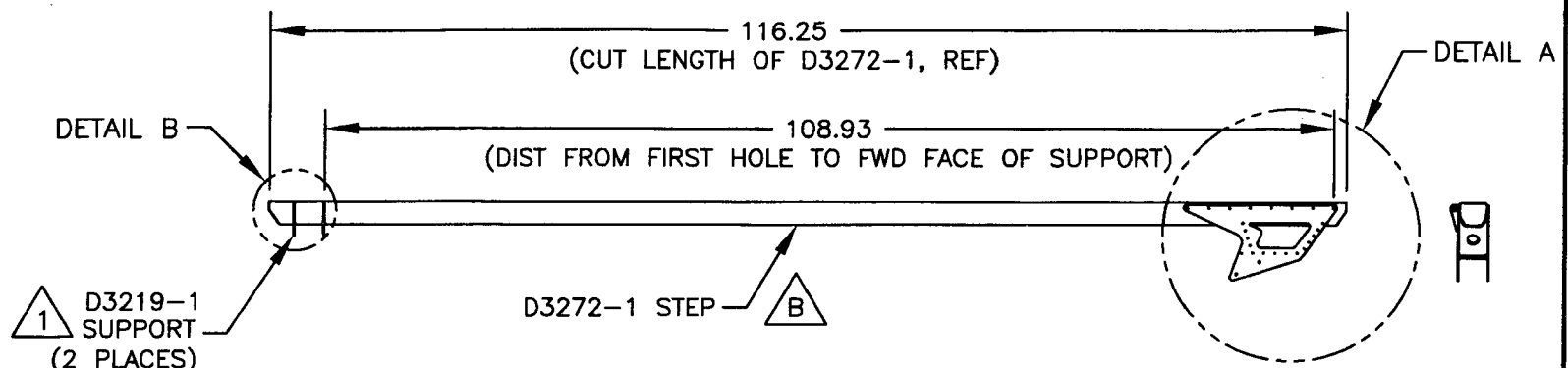
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

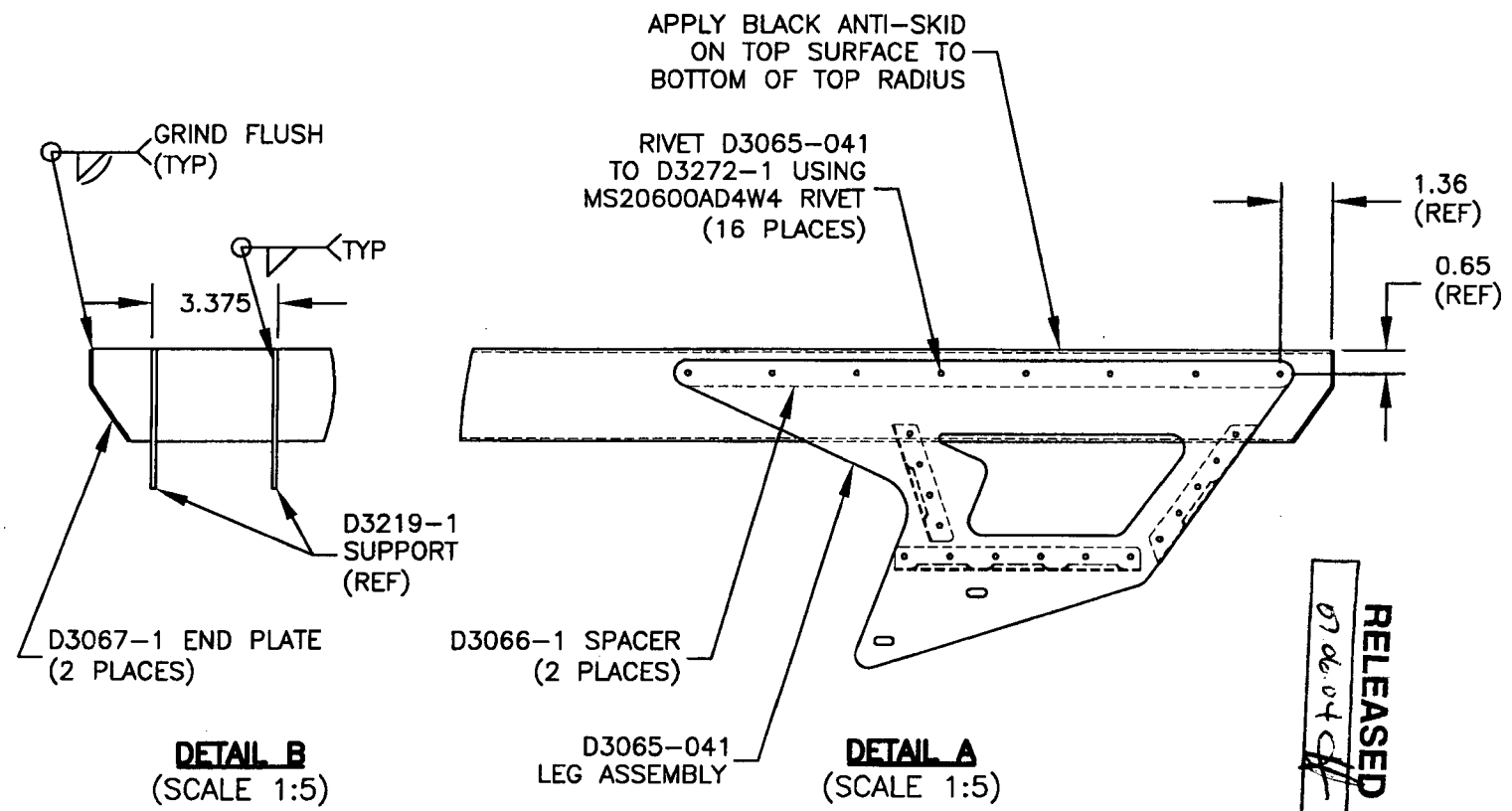
**NOTE:** Date & initial all entries

80775

**DART**



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



DESIGN	90	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED		REV. B
DATE	07.05.18	DRAWING NO.	D3272	SHEET 2 OF 3
		TITLE	STEP ASSEMBLY, HI LONG	SCALE 1:20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

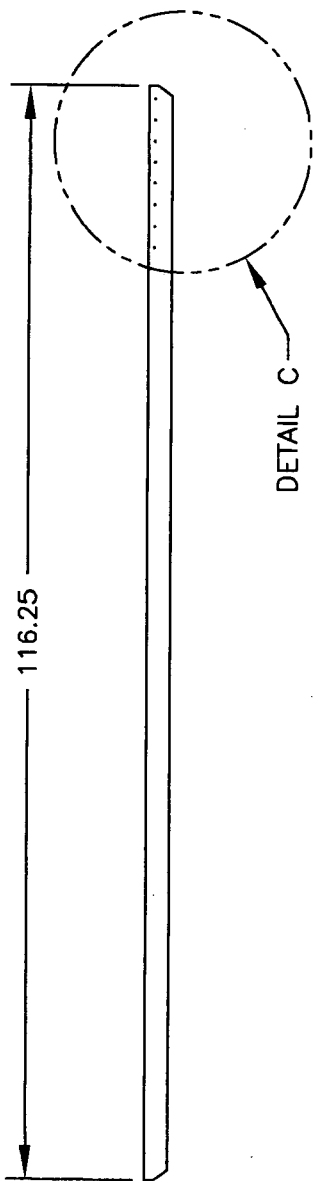
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

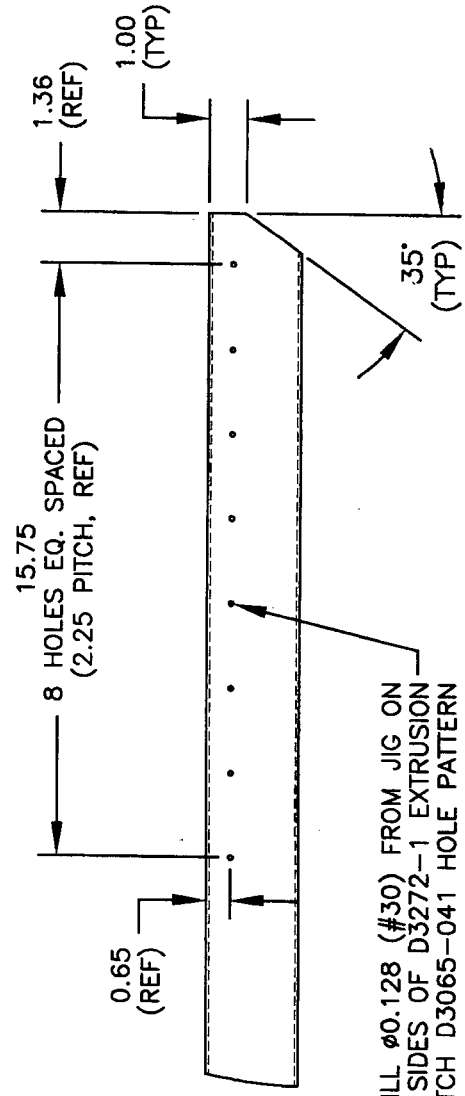


DESIGN 90	DRAWN BY JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

80178



**B** D3272-1 STEP  
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

RELEASED  
07.06.04 [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# REFERENCE ONLY

DART AEROSPACE LTD.

D350-591  
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.